

SPLIT

Date: Tuesday, 08/01/2008 3:19:44 PM
User: Jean-Luc Menard

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: 03.250 SUPPORT	
Job Number	: 35582 - /		Part Number	: D29401	
Estimate Number	: 10387		Drawing Number	: D2940 REV B	
P.O. Number	:		Project Number	: N/A	
This Issue	: 08/01/2008 S.O. No. :		Drawing Revision	: B	
Prsht Rev.	: NC		Material	:	
First Issue	: 06/11/2007 Type : MACHINED PARTS		Due Date	: 13/12/2007	
Previous Run	: 35478		Qty:	10	
Written By	: <i>JLM 08-01-08</i>		Um:	Each	
Checked & Approved By	:			<i>SPIT-16</i>	
Comment	: Est. C 02.11.26 Reformat; Added P/O KJ Est Rev:D Added priming as per Rev B 07-04-30 JLM			<i>32</i>	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D6104007	17-4 SS Roundbar 4.50"OD	
		Comment: Qty.: 1.0000 Each(s)/Unit Total: 20.0000 Each(s) 17-4 SS Roundbar 4.50"OD <i>35582A X8</i>	
		D6104-007 BATCH: <i>35582A</i>	
2.0	35582A	ROUND BILLET 17-4	
		Comment: Sub-Component ROUND BILLET 17-4 D6104-007 B	<i>20 08/01/09</i>
3.0	DOOSAN LATHE	DOOSAN LATHE	
		Comment: Doosan Turn blank for Haas as per Folio FA079	<i>N/A 20 08/01/09</i>
4.0	QC1	INSPECT ALL DIM TO DIM SHEET	
		Comment: INSPECT ALL DIM TO DIM SHEET	<i>20 08/03/18 20</i>
5.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	
		Comment: HAAS 1- Machine as per Folio FA079 2- Tumble & Deburr	<i>9/20/08 08/04/07</i>

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 03.250 SUPPORT

Job Number: 35582

Part Number: D29401

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC1 INSPECT ALL DIM TO DIM SHEET



Comment: INSPECT ALL DIM TO DIM SHEET

ML / 20 / J.L. 08/01/07

7.0 QC8 SECOND CHECK



Comment: SECOND CHECK

J.L. 08-04-07 08-04-07 (8)

8.0 POWDER COATING POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3

*****Mask Inside Surface as per Dwg D2940*****

PL 107550



(16)

BL 08-04-07

9.0 SPRAY PAINTING SPRAY PAINTING



Comment: SPRAY PAINTING



Prime inside surface as per Dwg D2940 and QSI 005 4.3.

IT 08 04 07

10.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

IT 08 - 04 - 08

11.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: X-tube assy

IT 08-04-08

12.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE



08/04/09 XJ

Job Completion



(16)
XJ

W
UMF 08-04-08

DART AEROSPACE LTD

Work Order:

35582

Description: Ø3.250 Support

Part Number:

D2940-1

Inspection Dwg: D2940 Rev. B

Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2940 Rev. B / DSK081 Rev. B & record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
Lathe Section									
A	3.211	3.216		3.215	3.215	3.215	3.215		
B	4.946	4.966		4.956	4.956	4.956	4.956		
C	0.718	0.738		.726	.726	.724	.724		
D	0.090	0.110		.102	.102	.102	.102		
E	3.564	3.584		3.574	3.574	3.574	3.574		
F	0.022	0.042		.03	.03	.03	.03		
G	3.444	3.464		3.454	3.454	3.454	3.454		
H	0.112	0.132		.122	.122	.122	.122		
I	2.170	2.190		2.18	2.18	2.18	2.18		
J	4.451	4.471		4.461	4.461	4.461	4.461		
K	0.413	0.433		.423	.423	.423	.423		
L	0.913	0.933		.923	.923	.923	.923		
M									
N									
HAAS Section									
AA	0.240	0.260		.250	.250	.250	.250		
AB	0.490	0.510		.500	.500	.500	.500		
AC	0.140	0.160		.150	.150	.156	.155		
AD	3.510	3.530		3.574	3.525	3.523	3.522		
AE	1.633	1.673		1.647	1.656	1.656	1.664		
AF	1.493	1.513		1.497	1.502	1.500	1.506		
AG	0.040	0.060		.051	.050	.052	.053		
AH	0.188	0.193		.188	.188	.188	.188		
AI	0.140	0.160		.148	.153	.153	.155		
AJ	2.518	2.538		2.530	2.530	2.530	2.530		
AK	0.040	0.060		.051	.051	.053	.052		
AL	0.010	0.020		.015	.015	.015	.015		
AM	0.140	0.160		.154	.154	.152	.152		
AN	0.350	0.450		.355	.355	.360	.360		
AO	0.240	0.260		.250	.250	.250	.250		
AP	0.150	0.170		.150	.154	.155	.157		
AQ	0.053	0.073		.063	.063	.063	.063		
AR	101.64	105.64		103.64	103.64	103.64	103.64		
AS	0.260	0.267		.260	.260	.260	.260		
AT	0.053	0.073		.063	.063	.063	.063		
AU	4.118	4.138		4.128	4.126	4.127	4.126		
AV									
Accept/Reject				<i>Pass</i>					

Measured by: *JL*
 Date: *08/03/15 / 08/04/100*

Audited by: *JL*
 Date: *08/04/07*

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	07.05.08	Dwg Rev. updated	KJ/JLM	
C	07.07.18	Dimension AS revised	KJ/JLM <i>JL</i>	<i>EE</i>

DART AEROSPACE LTD	Work Order:	35582
Description: Ø3.250 Support	Part Number:	D2940-1
Inspection Dwg: D2940 Rev. B		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2940 Rev. B / DSK081 Rev. B & record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	15	16	17	18	By	Date
Lathe Section									
A	3.211	3.216		3.215	3.215	3.215	3.215		
B	4.946	4.966		4.956	4.956	4.956	4.956		
C	0.718	0.738		.725	.725	.721	.725		
D	0.090	0.110		.103	.102	.102	.103		
E	3.564	3.584		3.574	3.574	3.574	3.574		
F	0.022	0.042		.03	.03	.03	.03		
G	3.444	3.464		3.454	3.454	3.454	3.454		
H	0.112	0.132		.128	.122	.122	.122		
I	2.170	2.190		2.18	2.18	2.18	2.18		
J	4.451	4.471		4.461	4.461	4.461	4.461		
K	0.413	0.433		.423	.423	.423	.423		
L	0.913	0.933		.923	.923	.923	.923		
M									
N									
HAAS Section									
AA	0.240	0.260		.250	.250	.250	.250		
AB	0.490	0.510		.500	.500	.500	.500		
AC	0.140	0.160		.152	.153	.152	.151		
AD	3.510	3.530		3.523	2.522	2.523	2.524		
AE	1.633	1.673		1.662	1.661	1.661	1.660		
AF	1.493	1.513		1.501	1.507	1.506	1.502		
AG	0.040	0.060		.052	.053	.053	.052		
AH	0.188	0.193		.188	.188	.188	.188		
AI	0.140	0.160		.152	.153	.152	.153		
AJ	2.518	2.538		2.530	2.530	2.530	2.530		
AK	0.040	0.060		.052	.051	.050	.051		
AL	0.010	0.020		.015	.015	.015	.015		
AM	0.140	0.160		.153	.152	.149	.148		
AN	0.350	0.450		.360	.360	.360	.360		
AO	0.240	0.260		.250	.250	.250	.250		
AP	0.150	0.170		.156	.155	.156	.157		
AQ	0.053	0.073		.063	.063	.063	.063		
AR	101.64	105.64		103.64	103.64	103.64	103.64		
AS	0.260	0.267		.260	.260	.260	.260		
AT	0.053	0.073		.063	.063	.063	.063		
AU	4.118	4.138		4.122	4.125	4.125	4.126		
AV									
Accept/Reject									

Measured by:	20	/	JL	Audited by:		
Date:	05/03/15	/	08/04/07	Date:	08-09-07	

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	07.05.08	Dwg Rev. updated	KJ/JLM	
C	07.07.18	Dimension AS revised	KJ/JLM	E

DART AEROSPACE LTD	Work Order:	35582
Description: Ø3.250 Support	Part Number:	D2940-1
Inspection Dwg: D2940 Rev. B		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2940 Rev. B / DSK081 Rev. B & record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	19	210	311	412	By	Date
Lathe Section									
A	3.211	3.216		3.215	3.215	3.215	3.215		
B	4.946	4.966		4.956	4.956	4.956	4.956		
C	0.718	0.738		.722	.724	.725	.727		
D	0.090	0.110		.102	.102	.103	.102		
E	3.564	3.584		3.574	3.574	3.574	3.574		
F	0.022	0.042		.03	.03	.03	.03		
G	3.444	3.464		3.454	3.454	3.454	3.454		
H	0.112	0.132		.122	.122	.122	.122		
I	2.170	2.190		2.18	2.18	2.18	2.18		
J	4.451	4.471		4.461	4.461	4.461	4.461		
K	0.413	0.433		.423	.423	.423	.423		
L	0.913	0.933		.923	.923	.923	.923		
M									
N									
HAAS Section									
AA	0.240	0.260							
AB	0.490	0.510							
AC	0.140	0.160							
AD	3.510	3.530							
AE	1.633	1.673							
AF	1.493	1.513							
AG	0.040	0.060							
AH	0.188	0.193							
AI	0.140	0.160							
AJ	2.518	2.538							
AK	0.040	0.060							
AL	0.010	0.020							
AM	0.140	0.160							
AN	0.350	0.450							
AO	0.240	0.260							
AP	0.150	0.170							
AQ	0.053	0.073							
AR	101.64	105.64							
AS	0.260	0.267							
AT	0.053	0.073							
AU	4.118	4.138							
AV									
Accept/Reject									

Measured by:	<i>RF</i>	Audited by:	<i>RF</i>
Date:	<i>08/03/18</i>	Date:	<i>08/07/18</i>

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	07.05.08	Dwg Rev. updated	KJ/JLM	
C	07.07.18	Dimension AS revised	KJ/JLM <i>RF</i>	<i>EE</i>

DART AEROSPACE LTD

Work Order:

35582

Description: Ø3.250 Support

Part Number:

D2940-1

Inspection Dwg: D2940 Rev. B

Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2940 Rev. B / DSK081 Rev. B & record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1/3	2 1/4	3 1/5	4 1/6	By	Date
Lathe Section									
A	3.211	3.216							
B	4.946	4.966		4.956	4.996	4.956	4.956		
C	0.718	0.738		.724	.726	.727	.728		
D	0.090	0.110		.102	.102	.102	.102		
E	3.564	3.584		3.574	3.574	3.574	3.574		
F	0.022	0.042		.03	.07	.03	.03		
G	3.444	3.464		3.454	3.454	3.454	3.454		
H	0.112	0.132		.122	.122	.122	.122		
I	2.170	2.190		2.180	2.180	2.180	2.180		
J	4.451	4.471		4.461	4.461	4.461	4.461		
K	0.413	0.433		.423	.423	.423	.423		
L	0.913	0.933		.923	.923	.923	.923		
M									
N									
HAAS Section									
AA	0.240	0.260							
AB	0.490	0.510							
AC	0.140	0.160							
AD	3.510	3.530							
AE	1.633	1.673							
AF	1.493	1.513							
AG	0.040	0.060							
AH	0.188	0.193							
AI	0.140	0.160							
AJ	2.518	2.538							
AK	0.040	0.060							
AL	0.010	0.020							
AM	0.140	0.160							
AN	0.350	0.450							
AO	0.240	0.260							
AP	0.150	0.170							
AQ	0.053	0.073							
AR	101.64	105.64							
AS	0.260	0.267							
AT	0.053	0.073							
AU	4.118	4.138							
AV									
Accept/Reject									

Measured by:

AC
63/03/18

Audited by:

Date:

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	07.05.08	Dwg Rev. updated	KJ/JLM	
C	07.07.18	Dimension AS revised	KJ/JLM	EZ

DART AEROSPACE LTD	Work Order:	35582
Description: Ø3.250 Support	Part Number:	D2940-1
Inspection Dwg: D2940 Rev. B		Page 1 of 1

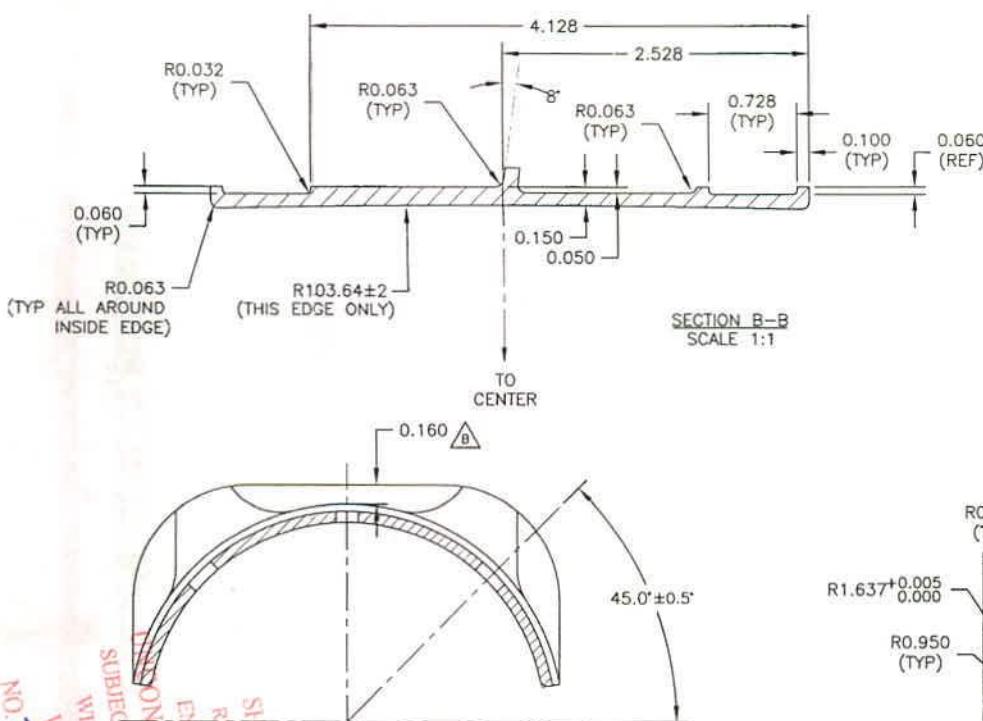
Inspect dimensions highlighted on inspection sheet drawing D2940 Rev. B / DSK081 Rev. B & record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1.17	2.18	3.19	4.20	By	Date
Lathe Section									
A	3.211	3.216		3.215	3.215	3.215	3.215		
B	4.946	4.966		4.956	4.956	4.956	4.956		
C	0.718	0.738		.728	.728	.728	.728		
D	0.090	0.110		.102	.102	.102	.102		
E	3.564	3.584		3.574	3.574	3.574	3.574		
F	0.022	0.042		.03	.03	.03	.03		
G	3.444	3.464		3.454	3.454	3.454	3.454		
H	0.112	0.132		.122	.122	.122	.122		
I	2.170	2.190		2.180	2.180	2.180	2.180		
J	4.451	4.471		4.461	4.461	4.461	4.461		
K	0.413	0.433		.423	.423	.423	.423		
L	0.913	0.933		.923	.923	.923	.923		
M									
N									
HAAS Section									
AA	0.240	0.260							
AB	0.490	0.510							
AC	0.140	0.160							
AD	3.510	3.530							
AE	1.633	1.673							
AF	1.493	1.513							
AG	0.040	0.060							
AH	0.188	0.193							
AI	0.140	0.160							
AJ	2.518	2.538							
AK	0.040	0.060							
AL	0.010	0.020							
AM	0.140	0.160							
AN	0.350	0.450							
AO	0.240	0.260							
AP	0.150	0.170							
AQ	0.053	0.073							
AR	101.64	105.64							
AS	0.260	0.267							
AT	0.053	0.073							
AU	4.118	4.138							
AV									
Accept/Reject									

Measured by:	RD	Audited by:	
Date:	08/03/18	Date:	

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	07.05.08	Dwg Rev. updated	KJ/JLM	
C	07.07.18	Dimension AS revised	KJ/JLM	EE

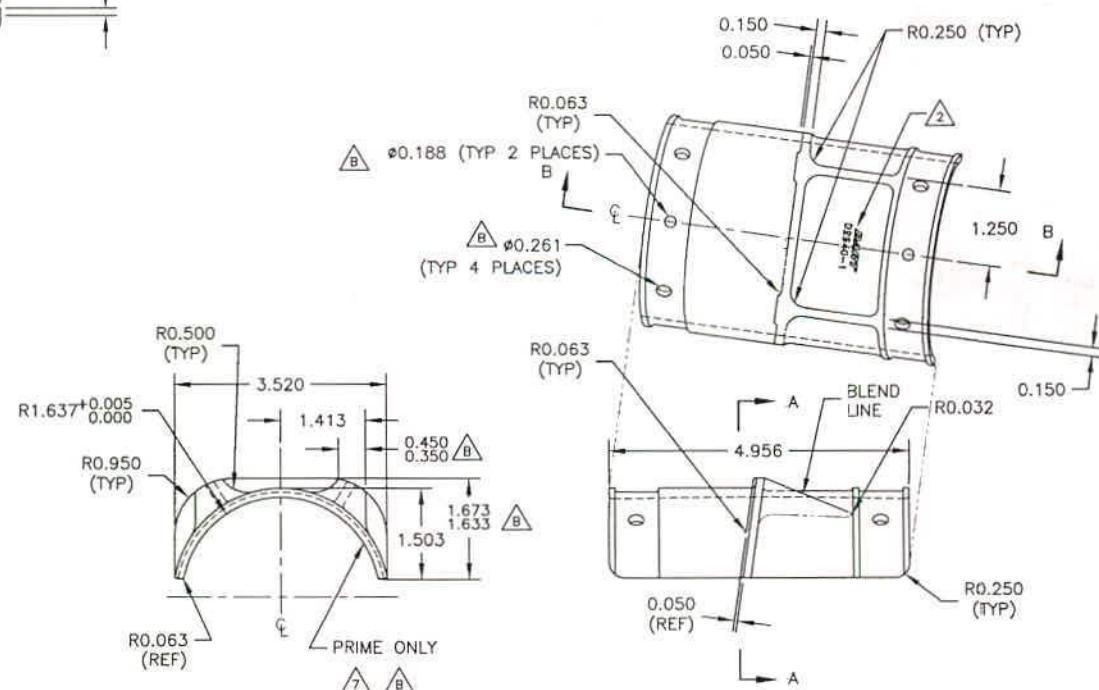
RELEASED
07.04.24 4P
PER ECN 827



NO. 3555
WORK ORDER
SUBJECT TO AMENDMENT
CONTROLLED COPY
ENGINEERING
RETURN TO
SHOP COPY
WITHOUT NOTICE

D2940-1

- 1) MATERIAL: 17-4 PH STAINLESS STEEL
HEAT TREAT TO H900 CONDITION
(900°F FOR 1 HR, AIR COOL)
MIN UTS = 170 KSI (38 HRc)
- 2) IDENTIFY WITH DART LOGO AND PART NUMBER IN THIS AREA
WITH 0.125 HIGH LETTERING 0.010-0.020 DEEP
- 3) BREAK ALL UNMARKED SHARP EDGES 0.010 TO 0.020
- 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) FINISH: POWDER COAT WHITE (REF 4.3.5.2) PER DART QSI 005 4.3
PRIME INSIDE SURFACE AS SHOWN PER DART QSI 005 4.2



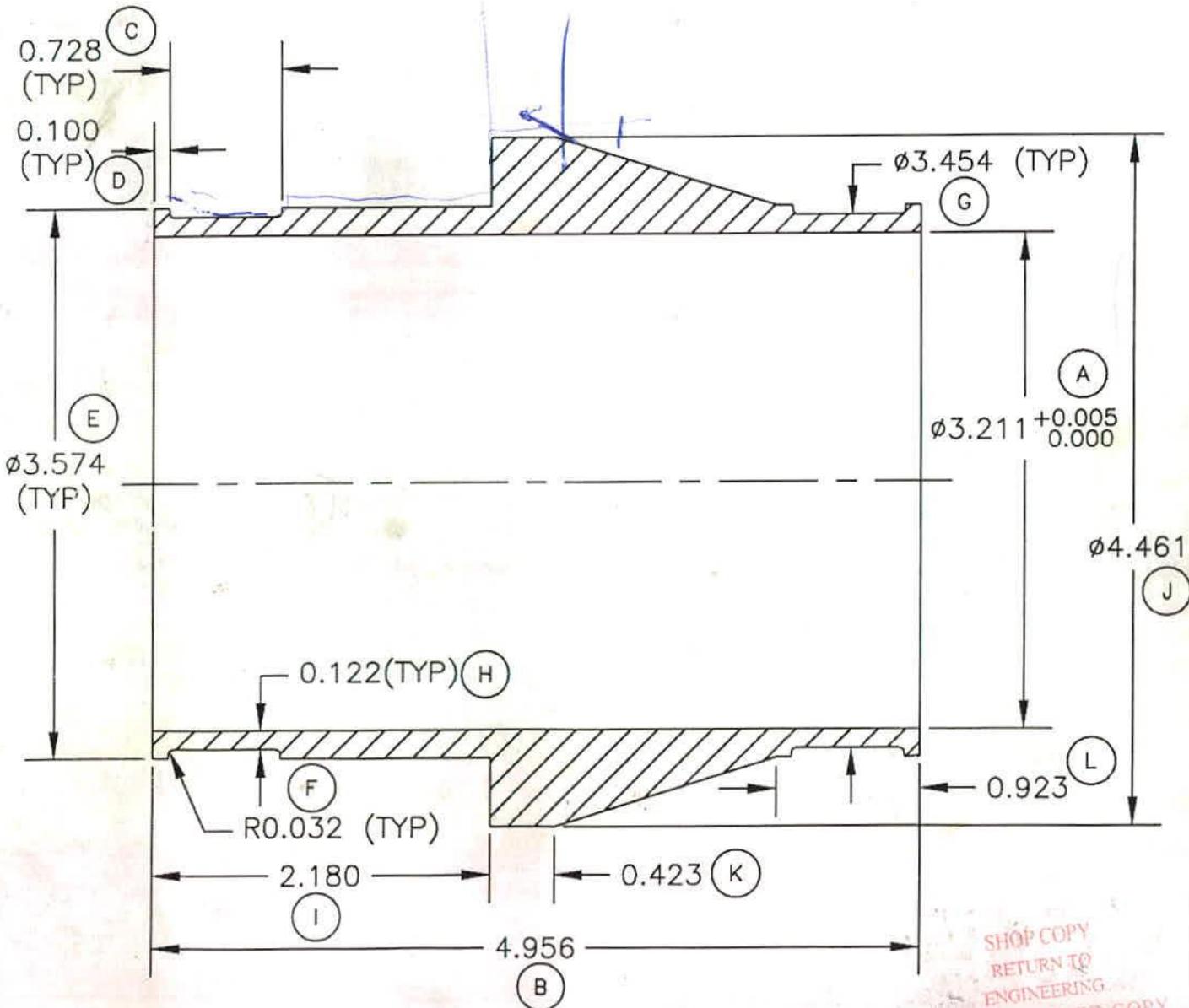
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DART AEROSPACE LTD.

B	07.03.16	UPDATE PER NCR 642, PRIME INSIDE
A	01.01.10	NEW ISSUE
DESIGN	DRAWN BY	DART
CHECKED	APPROVED	DART AEROSPACE LTD. HAWKSBURY, ONTARIO, CANADA
DATE	TITLE	REV. B SHEET 1 OF 1 07.03.16 Ø3.250 SUPPORT

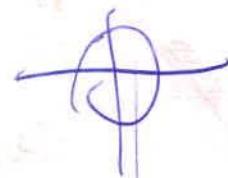
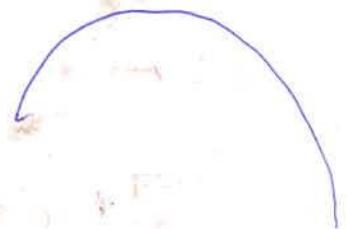
DART

DESIGN <i>KF</i>	DRAWN BY <i>KF</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>H</i>	APPROVED <i>H</i>	DRAWING NO. DSK 081	REV. B SHEET 1 OF 1
DATE 03.06.24		TITLE TURNING DETAIL FOR D2940-1	SCALE 1:1
A	03.03.07	NEW ISSUE	
B	03.06.24	ADDED 4.956 DIMENSION	

RELEASED
03-07-01 *H*

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WITHOUT NOTICE
WORK ORDER
NO. 35582

$\propto 2.974$



603 $\propto 3.074 \pm .05$ R₄

- .05

